

Work Order ID 75289

75289

Page 1

October-20-11 9:56:08 AM

Item ID: D205-633-017

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 20/10/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/10/20 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 90540	A								
IIN-D205-633	B								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D205-633-017 CHG001/ DSI 9540								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

Pro →
JG Cor MLJ 11-11-14

Sulu15

11/11/14 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-633-017 PAR #: N/A Fault Category: Production Eng. NCR: Yes No QDA: a Date: 11/11/21
 Resolution: Rework Disposition: Rework QA: N/C Closed Date: 11/11/21

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/11/21	#100	Qty for A1960SD516 washer is wrong. not x3 should be x4. R.L. LOP was correct w/h	CP 11.11.21 PS1672	ADD Qty x1 per each kit correct w/o + Bom: ADD copy of Bom for Ref.	<u>[Signature]</u> 11/11/21	<u>[Signature]</u> 11/11/21	<u>[Signature]</u> 11.11.21 PS1672	<u>[Signature]</u> 11/11/21

NOTE: Date & initial all entries

Work Order ID 75289***75289***

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October-20-11 9:56:08 AM

Item ID: D205-633-017

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 20/10/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-633-017/ DSI 9540

Location: 70

PPP Rev: _____

140

QC21- Final Inspection - Work Order Release

0.00


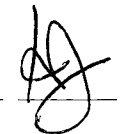
140

QC

Memo

0.00

Quality Control

 2011/11/17 P111-17 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-20-11 9:56:12 AM

Page 1

Work Order ID: 75289

75289

Parent Item: D205-633-017

D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 04.05.10 New IssueKJ/JLM

IPP REV:B

11.01.12 AS PER DSI 9540 REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A

Purchased

No

110

Each

263.0000

1

2

AN4-14A

Bolt

**

Location

Loc Qty

Loc Code

ST357

263

118628

100

118706

63

119127

100

Purchased

No

110

Each

166.0000

2

AN4-5A

AN4-5A

Bolt

**

Location

Loc Qty

Loc Code

ST355

166

116549

6

117508

160

Purchased

No

110

Each

5,880.000

2

4

AN4-6A

AN4-6A

Bolt

**

Location

Loc Qty

Loc Code

ST356

874

118628

374

118838

300

119127

200

ST358

6

117514

6

ST516

5000

119017

5000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75289

75289

Parent Item: D205-633-017

D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-7A Purchased No

110 Each 200.0000

AN4-7A

Bolt

**

Location

Loc Qty

Loc Code

ST356

200

117514

200

AN5-14A Purchased No

110 Each 76.0000

AN5-14A

Bolt

**

Location

Loc Qty

Loc Code

ST338

76

115374

26

119127

50

AN5-6A Purchased No

110 Each 52.0000

AN5-6A

Bolt

**

Location

Loc Qty

Loc Code

ST337

52

117313

2

117688

50

AN960JD416 NAS1149D0463J Purchased No

110 Each 0.0000

AN960.ID416

Washer

**

AN960JD516 NAS1149D0563J Purchased No

110 Each 0.0000

AN960.ID516

Washer

**

October-20-11 9:56:12 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75289

75289

Parent Item: D205-633-017

D205-633-017

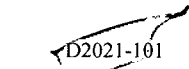
Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 2.00

Required Qty: 2.00


D2021-101
D2021-101
Eyebolt

Manufactured	No	110	Each	22.0000
--------------	----	-----	------	---------

**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST004	22	
-------	----	--

69527	22	
-------	----	--

Manufactured	No	110	Each	122.0000
--------------	----	-----	------	----------

**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST504	122	
-------	-----	--

69824	12	
-------	----	--

71840	60	
-------	----	--

73307	50	
-------	----	--

Manufactured	No	110	Each	99.0000
--------------	----	-----	------	---------

**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST	40	
----	----	--

71862	40	
-------	----	--

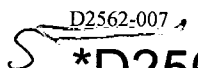
ST005	59	
-------	----	--

69550	19	
-------	----	--

74531	40	
-------	----	--

Manufactured	No	110	Each	6.0000
--------------	----	-----	------	--------

**


D2562-007
D2562-007
Strut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST264	6	
-------	---	--

62783	6	
-------	---	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-20-11 9:56:12 AM

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Work Order ID: 75289

75289

Parent Item: D205-633-017

D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 2.00

Required Qty: 2.00

D2563		Manufactured	No		110	Each	0.0000	Start Qty: 2.00		Required Qty: 2.00										
D2563								1 2		** B75285										
Step Weldment Assembly																				
D2565-401		Manufactured	No		110	Each	3.0000	1		**										
D2565-401																				
Strut																				
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST259</td><td>3</td><td></td></tr><tr><td>62784</td><td>3</td><td></td></tr></table>												Location	Loc Qty	Loc Code	ST259	3		62784	3	
Location	Loc Qty	Loc Code																		
ST259	3																			
62784	3																			
D2565-403		Manufactured	No		110	Each	3.0000	1 2		**										
D2565-403																				
Strut																				
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST259</td><td>3</td><td></td></tr><tr><td>62785</td><td>3</td><td></td></tr></table>												Location	Loc Qty	Loc Code	ST259	3		62785	3	
Location	Loc Qty	Loc Code																		
ST259	3																			
62785	3																			
D2565-405		Manufactured	No		110	Each	3.0000	1 2		**										
D2565-405																				
Strut																				
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST259</td><td>3</td><td></td></tr><tr><td>62786</td><td>3</td><td></td></tr></table>												Location	Loc Qty	Loc Code	ST259	3		62786	3	
Location	Loc Qty	Loc Code																		
ST259	3																			
62786	3																			
D2565-407		Manufactured	No		110	Each	3.0000	1 2		**										
D2565-407																				
Strut																				
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST259</td><td>3</td><td></td></tr><tr><td>62787</td><td>3</td><td></td></tr></table>												Location	Loc Qty	Loc Code	ST259	3		62787	3	
Location	Loc Qty	Loc Code																		
ST259	3																			
62787	3																			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-20-11 9:56:12 AM

Work Order ID: 75289

75289

Parent Item: D205-633-017

D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 2.00

Required Qty: 2.00

D2565-409
Strut
D2565-409

Manufactured No 110 Each 15.0000

**

Location	Loc Qty	Loc Code
ST259	15	
47831	9	
47899	6	

Manufactured No 110 Each 3.0000

**

Location	Loc Qty	Loc Code
ST259	3	
62788	3	

Purchased No 110 Each 13,982.00

**

MS21042L4
Nut
MS21042L4

Location	Loc Qty	Loc Code
ST300	2982	
117441	51	
117601	537	
118451	1394	
118927	1000	
ST516	6000	
119017	6000	
ST518	5000	
119075	5000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-20-11 9:56:12 AM

Work Order ID: 75289

75289

Parent Item: D205-633-017

D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

2,546.000

2

14

**

Handwritten signature and circled '2'

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1046

116105

5

116548

53

117441

110

117611

82

118179

496

118910

300

ST518

1500

119109

1500

Handwritten '2' and '2' with lines

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21

Status	Item ID	Rev	Name	Start Date	Quantity	Pe	UOM	Scrap %	Route Seq	II	Sort	Comments	Date Last Mod	Stop Date
	AN4-6A		Bolt	1/1/2008	2.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2565-403		Strut	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2565-407		Strut	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	AN5-14A		Bolt	1/1/2008	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	AN960JD416		Washer	1/1/2008	15.0000		Each	0 %	110		0		12/5/2009 6:...	
	AN960JD516		Washer	1/1/2008	4.0000		Each	0 %	110		0		1/12/2011 7:...	
	D2565-411		Strut	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2565-409		Strut	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2565-401		Strut	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2562-007		Strut	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2022-101		Spacer	12/5/2009	2.0000		Each	0 %	110		0		12/5/2009 8:...	
	AN4-5A		Bolt	1/1/2008	2.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2563		Step Weldment Assembly	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	AN4-14A		Bolt	1/1/2008	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	MS21042L5		Nut	1/1/2008	2.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2021-101		Eyebolt	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 8:...	
	MS21042L4		Nut	1/1/2008	8.0000		Each	0 %	110		0		12/5/2009 6:...	
	AN5-6A		Bolt	1/1/2008	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2565-405		Strut	12/5/2009	1.0000		Each	0 %	110		0		12/5/2009 6:...	
	AN4-7A		Bolt	1/1/2008	2.0000		Each	0 %	110		0		12/5/2009 6:...	
	D2022-103		Spacer	12/5/2009	2.0000		Each	0 %	110		0		12/5/2009 8:...	

